

Date: Friday, 12/2/2005 1:32:54 PM  
 User: Linda Lacelle

## Process Sheet

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : SUPPORT BRACKET
<b>Job Number</b> : 25073	
<b>Estimate Number</b> : 10260	
<b>P.O. Number</b> : N/A	<b>Part Number</b> : D23623
<b>This Issue</b> : 12/2/2005 <b>S.O. No.</b> : N/A	<b>Drawing Number</b> : D2362 REV E1
<b>Prsht Rev.</b> : NC	<b>Project Number</b> : N/A
<b>First Issue</b> : 12/1/2005 <b>Type</b> : MACHINED PARTS	<b>Drawing Revision</b> : E1
<b>Previous Run</b> : N/A	<b>Material</b> : N/A
<b>Written By</b> : <u>See comment below</u>	<b>Due Date</b> : 12/8/2005 <b>Qty:</b> 2 <b>Um:</b> Each
<b>Checked &amp; Approved By</b> : <u>See comment below</u>	
<b>Comment</b> : Est: G 00.05.18 Added inspection level 8 EC	

## Additional Product

Job Number:



Seq. #: Machine Or Operation:

Description :

1.0

HAAS1

HAAS CNC VERTICAL MACHINING #1

Comment: Take from stock D2362-5 B 13344 X2Machine per folio D2362-3 BL 05.12.05

2.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: Inspect Level 2

BL 05.12.05

2

3.0

QC8

SECOND CHECK



Comment: SECOND CHECK

SD 05.12.05

2

4.0

SMALL FAB 1

SMALL &amp; MEDIUM FAB RESOURCE 1



Comment: SMALL &amp; MEDIUM FAB RESOURCE 1

Deburr

BL 05.12.05

2

5.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Gloss White (Ref 4.3.5.1) as per Dart QSI 005 4.3

MM 05 12 08

2

6.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

SB 05/12/08

2

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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SUPPORT BRACKET

Job Number: 25073

Part Number: D23623

Job Number:



Seq. #: Machine Or Operation: Description :

7.0 D23971 Rubber Cushion



Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)

Rubber Cushion

Pick:

*made by Rand*

Qty Part number Description Batch

1 D2397-1 Rubber B16919

SB 05/12/08

8.0 D23973 Rubber Cushion



Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)

Rubber Cushion

Pick:

*made by Rand*

Qty Part number Description Batch

1 D2397-3 Rubber B16919

SB 05/12/08

9.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Bond rubber D2397-1 followed by D2397-3 using contact cement  
as per Dwg D2362

Batch M16194

SB 05/12/08

10.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*2*  
*05-12-08*

11.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 39

*16 05/12/09*

*(2)*

12.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

*(17) 05/12/09 (2)*

Job Completion



*u*





RELEASED  
98.12.14 KE

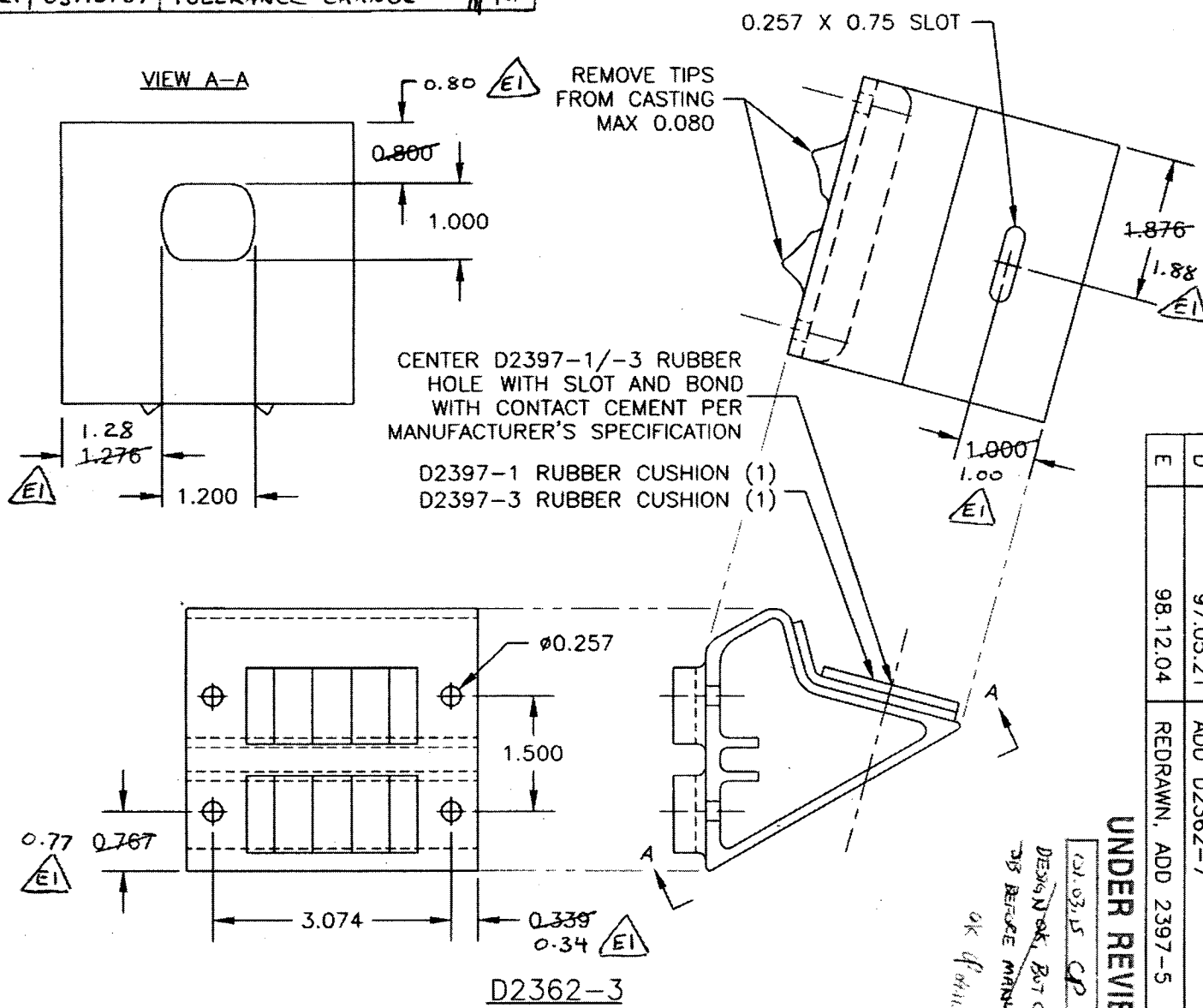
DESIGN	DRAWN BY	DART AEROSPACE LTD	REV. E
BW	CP	HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	SHEET 1 OF 3
KE	CP	D2362	
DATE		TITLE	SCALE
98.12.04		STEP SUPPORT BRACKET	1:2
A	95.02.15	NEW ISSUE	
B	95.03.22	CHANGED RUBBER TO D2397	
C	96.01.22	ADD D2362-5	
D	97.05.21	ADD D2362-7	
E	98.12.04	REDRAWN, ADD 2397-5	

UNDER REVIEW

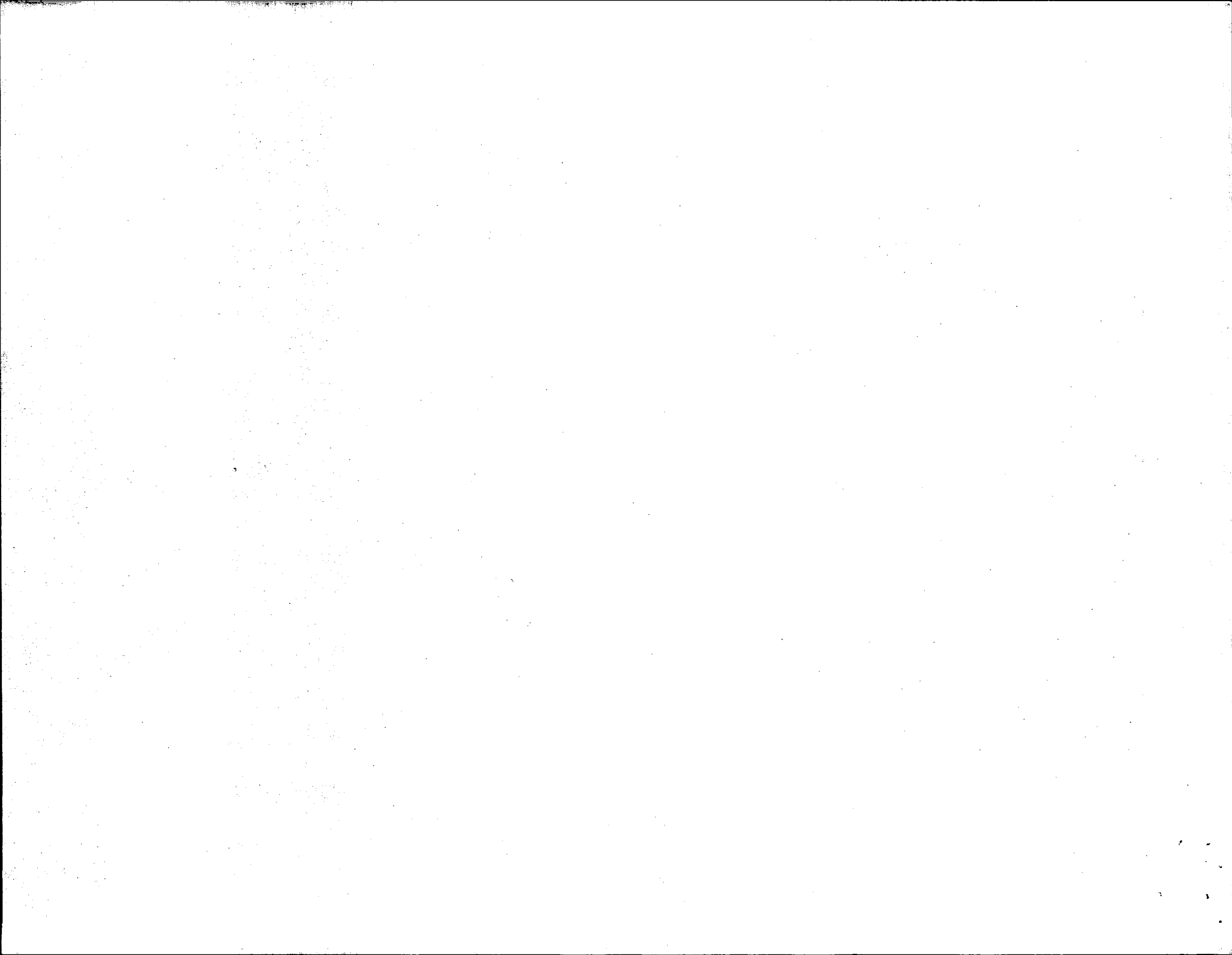
CP 03.15 CP

DESIGN OK, BUT CHECK WITH  
DB BEFORE MANUFACTURE  
OK 07/11/09

EI 03.10.07 TOLERANCE CHANGE ~~RF~~



NOTES:  
MAKE FROM D2265  
FINISH: POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3 BEFORE BONDING  
RUBBER IN PLACE  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



**DART**

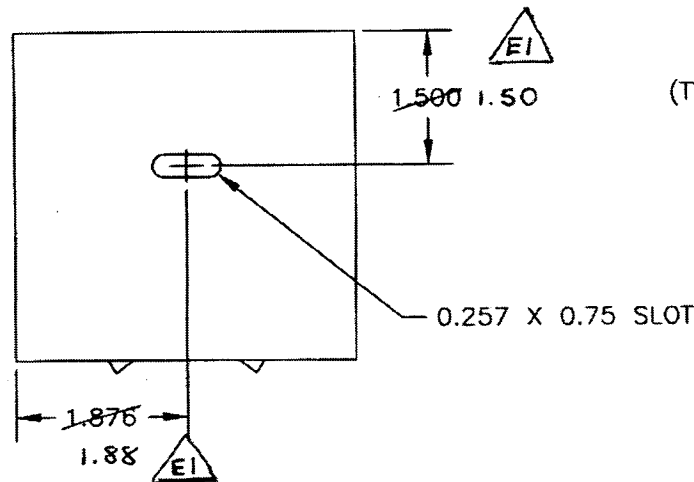


DESIGN	DRAWN BY	DART AEROSPACE LTD
BW	CP	HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.
KE	SP	D2362
DATE	TITLE	REV. E
98.12.04	STEP SUPPORT BRACKET	SHEET 2 OF 3
		SCALE
		1:2

**RELEASED**  
98.12.14 KE  
**UNDER REVIEW**

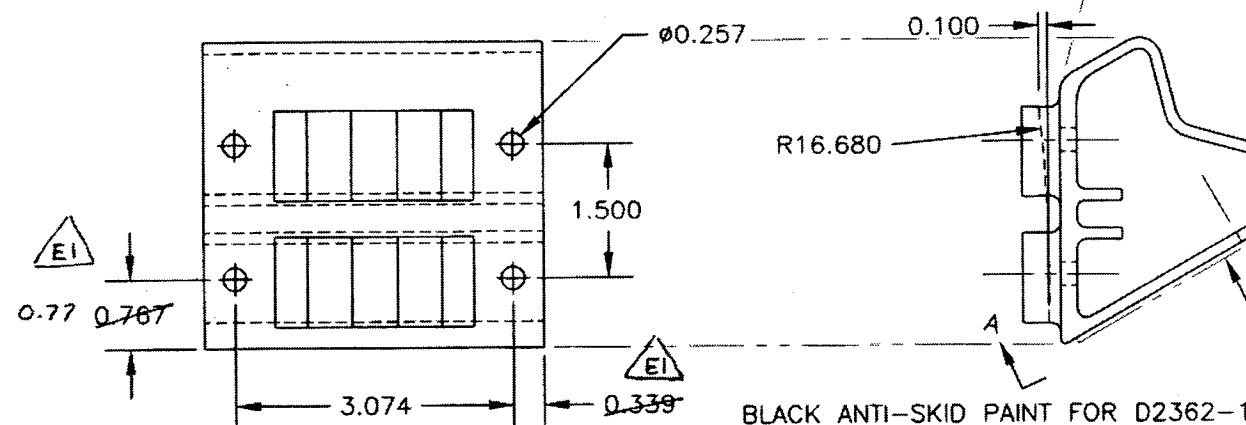
DESIGN OK, BUT CHECK W/  
DR BERTS MANUFACTURE  
OK 1/10/99

VIEW A-A



MACHINE TO  
R1.100  
(TYP 2 PLACES)

REMOVE TIPS  
FROM CASTING  
MAX 0.080



BLACK ANTI-SKID PAINT FOR D2362-1  
INSTALL D2397-5 (1) FOR D2362-5

D2362-1 & D2362-5

**NOTES:**

MAKE FROM D2265

D2362-1: BLACK ANTI-SKID PAINT PER DART QSI 005 4.4

D2362-5: INSTALL D2397-5 RUBBER CUSHION. ALIGN RUBBER HOLE WITH SLOT  
AND BOND USING CONTACT CEMENT PER MANUFACTURER'S SPECIFICATION

FINISH: POWDER COAT WHITE (REF. 4.3.5.1) PER QSI 005 4.3

BEFORE ANTI-SKID PAINT OR BEFORE INSTALLING D2397-5

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

**DART**



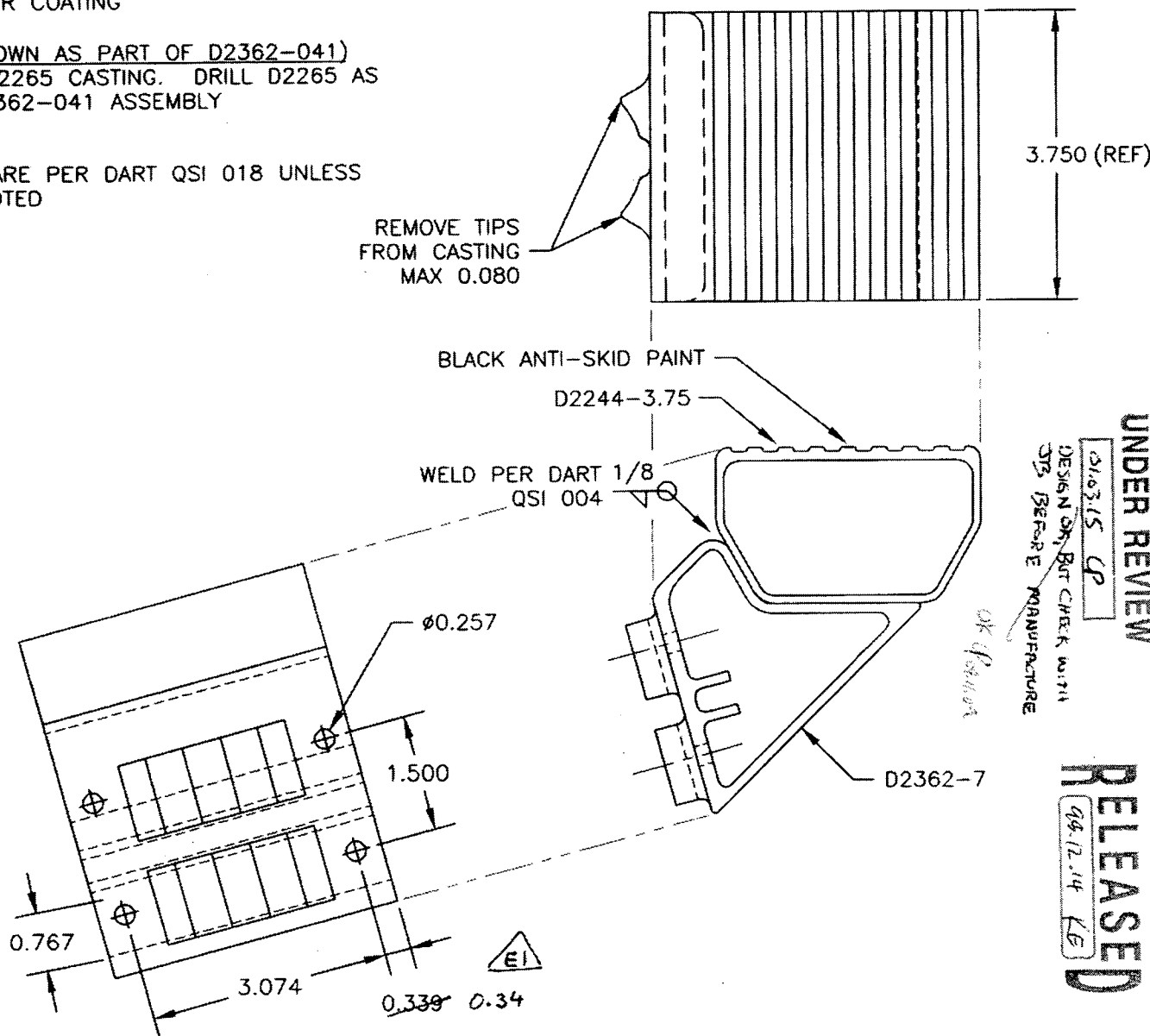
DESIGN	DRAWN BY	DART AEROSPACE LTD
BW	APPROVED	HAWKESBURY, ONTARIO, CANADA
CHECKED	DATE	REV. E
98.12.04	98.12.14 KE	SHEET 3 OF 3
STEP SUPPORT BRACKET	TITLE	SCALE
		1:2

UNDER REVIEW

RELEASED  
98.12.14 KE

DESIGN OK BUT CHECK WITH  
DTS BEFORE MANUFACTURE

OK (P. 11/10/04)



## Linda Lacelle

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**From:** David Shepherd [davids@dartaero.com]  
**Sent:** Thursday, December 01, 2005 8:11 PM  
**To:** Linda Lacelle  
**Subject:** Re: D2362

Hi Linda,

Looking at drawing D2362 Rev. E1, I think you can take a D2362-5 and convert it into a D2362-3.

You would have to add the 0.257 x 0.75 slot shown on page 1 and convert the existing 0.257 x 0.75 slot shown on page 2 into the 1.00 x 1.20 cutout shown on page 1. Then you would have to machine to remove the R16.68 shown on page 2.

Add the rubber and voila, D2362-3.

Good luck with that. Sorry for not getting back to you sooner.

David

----- Original Message -----

From: "Linda Lacelle" <llacelle@dartaero.com>  
To: "\*David Shepherd (E-mail)" <davids@dartaero.com>  
Sent: Thursday, December 01, 2005 7:24 AM  
Subject: D2362

>  
> David,  
> Is there much of a difference from D2362-5 AND D2362-3 ? Can we take a  
> D2362-5 and make it into a D2362-3 ?  
> LL  
>  
>  
>



